



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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12861

D3531-041 Job Sheet 189299



Part No: D3531-041

Job Qty: 4 pcs

Part Name: Top Mounted Gps Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/12/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 07-09-24 EC verified DD IPP REV:B 12.10.24 PER DWG REV.B DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	2/12/19	2/12/19	0.00	1.10	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		DAS 36 9-89
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	4 pcs	2/12/19	2/12/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		DAS FEB 14 2019 68 9-89
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
120	Powdercoat - 4 Black Sand - B4B	4 pcs	2/12/19	2/12/19	0.00	0.24	Powdercoat - 1 - B4B		
							Powdercoat - 2 - B4B		
							Powdercoat - 3 - B4B		
							Powdercoat - 4 - B4B		



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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S153551



Part: D3531 - 041

Job No: 189299

Serial No/Batch: S153551

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/14/19

120 Powdercoat - 4 Black Sand - B4B

4 pcs

2/12/19

0.00 0.24

Powdercoat - 1 - B4B

Powdercoat - 2 - B4B

Powdercoat - 3 - B4B

Powdercoat - 4 - B4B

START: 8:35 A.M. FINISH: 10:05

130 QC 3

4
pcs

2/12/19

0.00 0.00

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 26

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 38

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 6

QC 3 - 68

QC 3 - 9

DAS

50/ 68/19/02/19

9-89

140 Packaging 3-1 - Stock - B4B

4
pcs

2/12/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 -
B4BPackaging 3 - 11 -
B4BPackaging 3 - 12 -
B4BPackaging 3 - 13 -
B4BPackaging 3 - 14 -
B4BPackaging 3 - 15 -
B4BPackaging 3 - 16 -
B4BPackaging 3 - 17 -
B4BPackaging 3 - 18 -
B4BPackaging 3 - 19 -
B4BPackaging 3 - 20 -
B4BPackaging 3 - 21 -
B4BPackaging 3 - 22 -
B4BPackaging 3 - 23 -
B4BPackaging 3 - 24 -
B4BPackaging 3 - 25 -
B4B

Packaging 3 - 26 -

				B4B	
				Packaging 3 - 27 - B4B	503 SK FEB 19 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
150 QC 21 - SA	4	2/12/19	0.00 0.00	QC 21 - SA - 21	DAG 21 FEB 19 2019
	pcs			QC 21 - SA - 70	

Part Op 110 - (QC5- Inspect part completeness to step on W/O)
 Descriptions: 120 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3)
 130 - (QC3- Inspect Part Finish)
 140 - (Identify as per dwg & Stock Location:_____)
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3531-1	Bracket	4 pcs (1 ea)	100-Small Fab - 1	5081165
D3531-3	Bracket Front Plate	4 pcs (1 ea)	100-Small Fab - 1	5079490
MS20426AD4-4	Rivet	8 Ea (2 ea)	100-Small Fab - 1	5140396 5081165
MS20470AD4-4	Rivet, Universal Head	40 Ea (10 ea)	100-Small Fab - 1	5140396

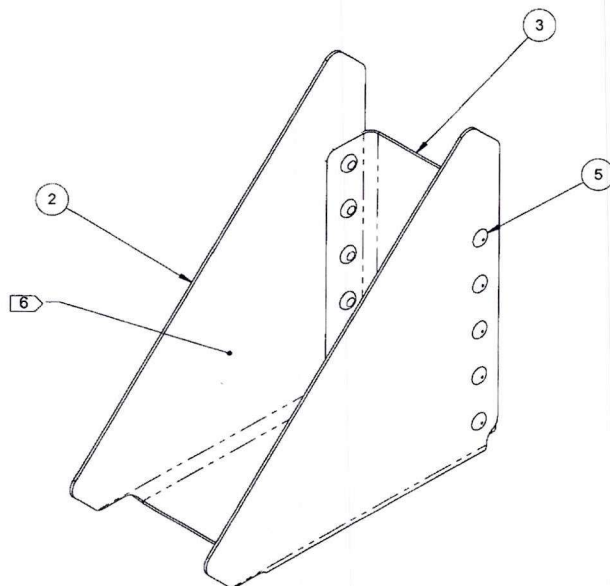
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	D3531-1	4	2	0
	D3531-3	4	0	0
	MS20426AD4-4	8	2,786	0
	MS20470AD4-4	40	36,156	0

Part Specifications

Specifications could not be found.

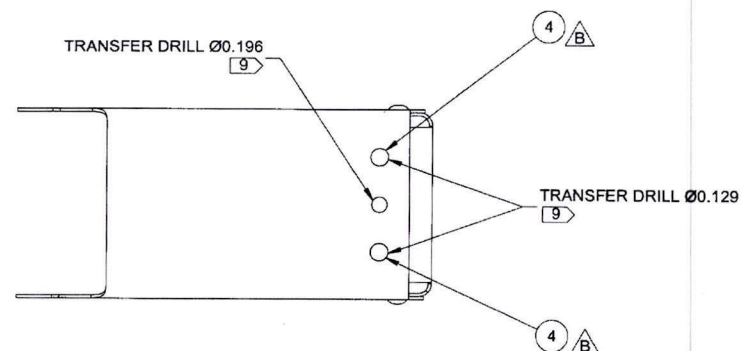
ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3531-041	BRACKET ASSEMBLY
2	1	D3531-1	BRACKET
3	1	D3531-3	BRACKET FRONT PLATE
4	2	MS20426AD4-4	RIVET
5	10	MS20470AD4-4	RIVET



D3531-041 BRACKET ASSEMBLY

NOTES:

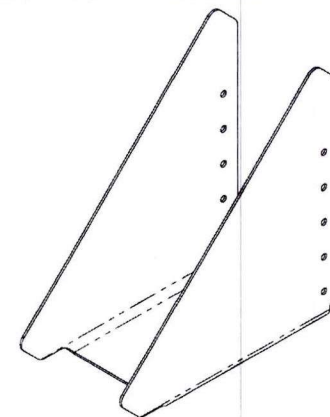
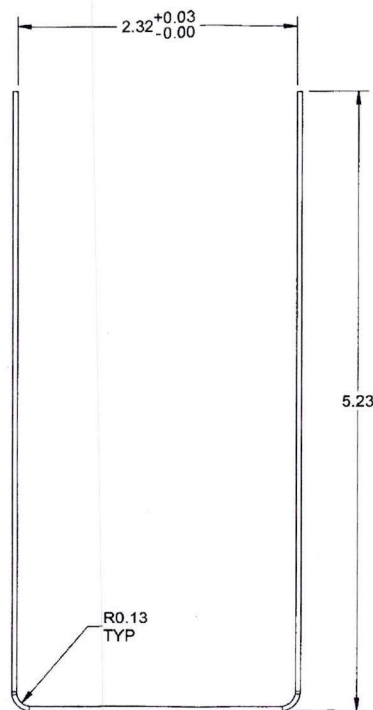
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON INSIDE OF BRACKET ASSEMBLY, WHERE INDICATED
- 7) WEIGHT: 0.22 lbs
- 8) ASSEMBLE PER DART QSI 003
- 9) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE BEFORE FINISHING



**D3531-041 BRACKET ASSEMBLY
BOTTOM VIEW**

RELEASED
12/10/23 9
PER BCN 12-659

B	CHANGE BOTTOM RIVETS FROM MS20470AD4-4 TO MS20426AD4-4, ZN C2-1, C5-3, ADD CSK, ZN C5-3, CORRECT BEND LINE DIM, ZN C4-3, UPDATE TO CURRENT DWG STANDARDS, REF PAR 10-47.	DC	12.08.09
A	NEW ISSUE	CB	07.06.19
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	SE	DRAWING NO.	REV. B
MFG. APPR.	SE	D3531	SHEET 1 OF 5
APPROVED	SE	TITLE	SCALE
DE APPR.	SE	BRACKET ASSEMBLY	NTS
DATE	12.08.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



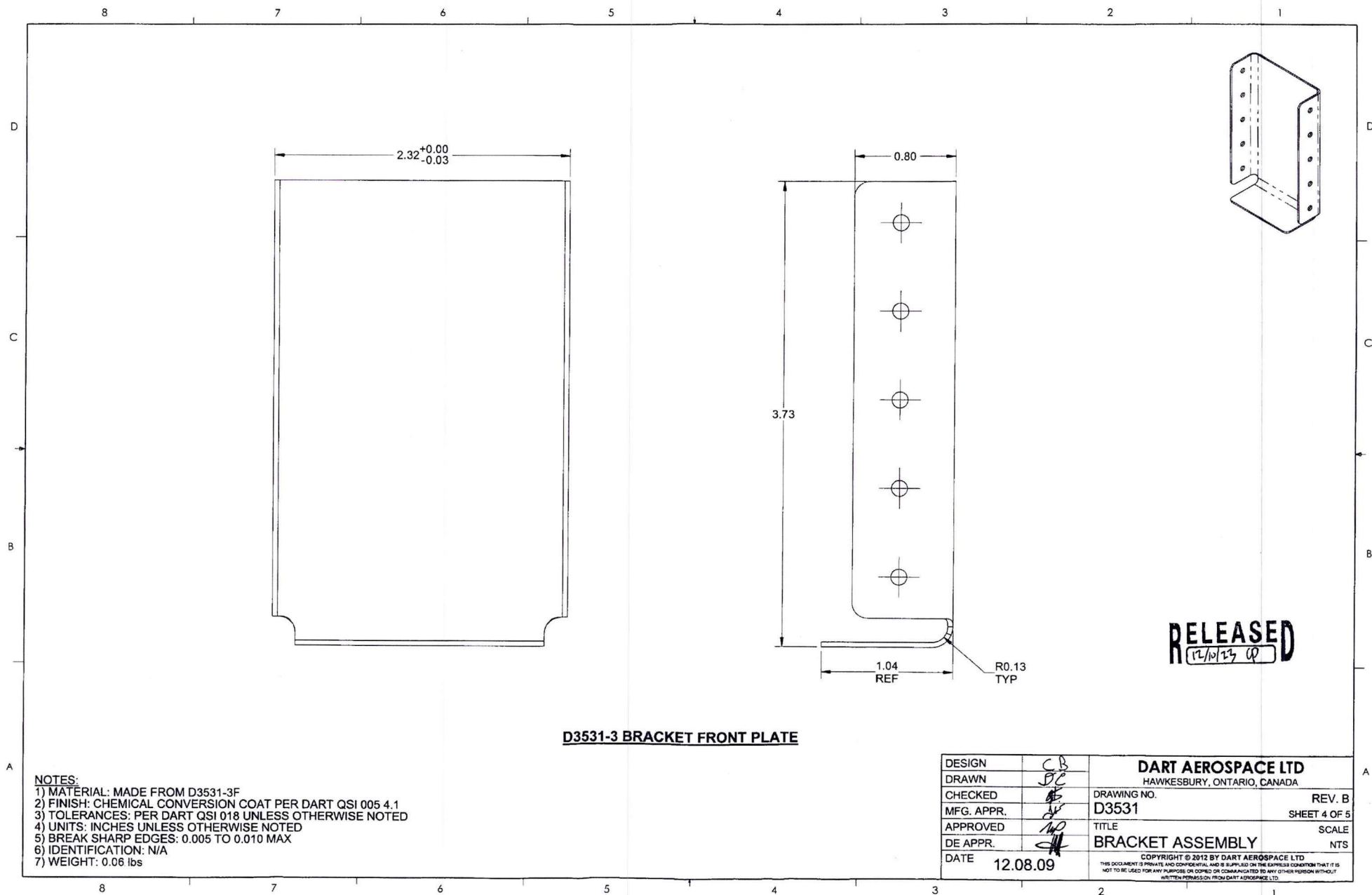
D3531-1 BRACKET

RELEASED
12/10/15

NOTES:

- 1) MATERIAL: MADE FROM D3531-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

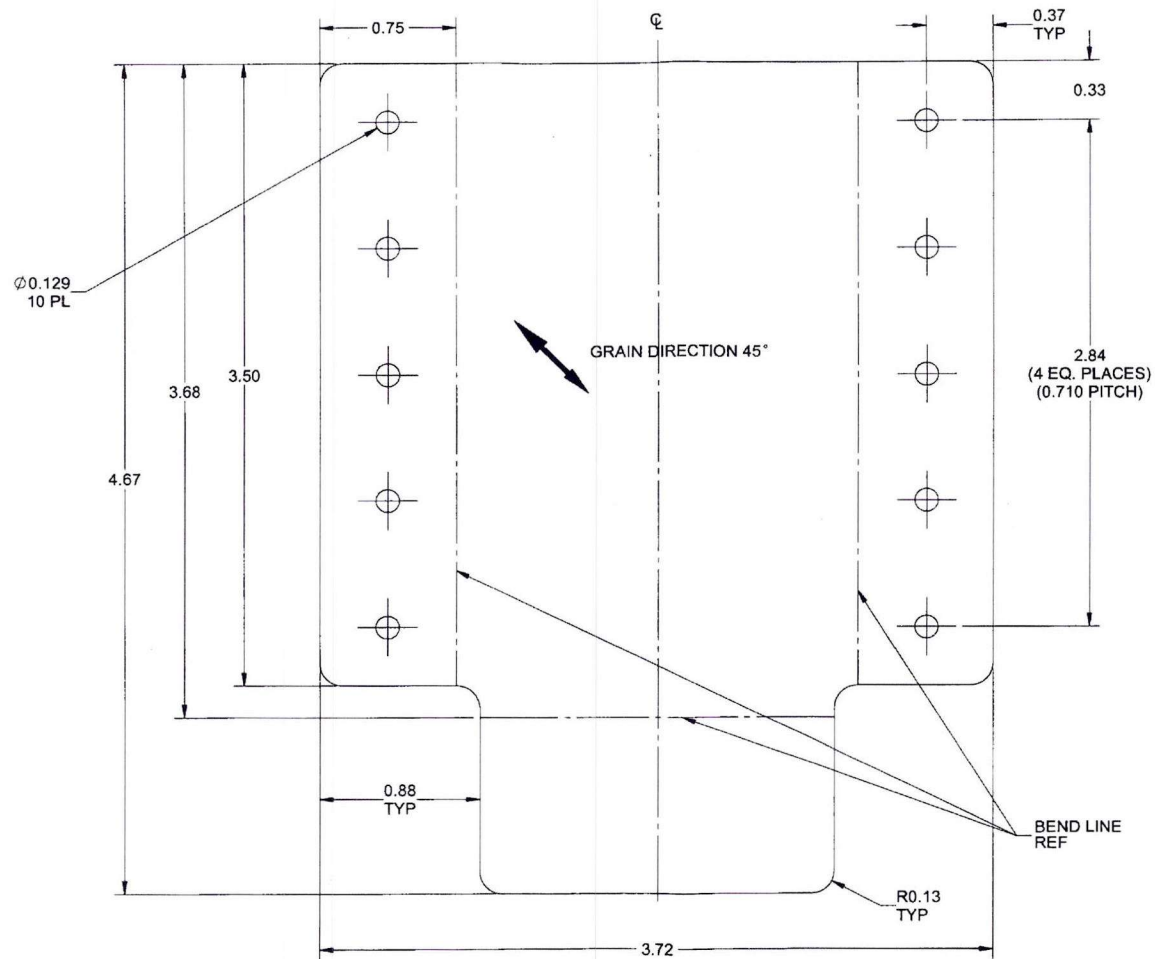
DESIGN	CB	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AB	DRAWING NO.	REV. B
MFG. APPR.	AP	D3531	SHEET 2 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	HA	BRACKET ASSEMBLY	NTS
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D3531-3 BRACKET FRONT PLATE

- NOTES:
- 1) MATERIAL: MADE FROM D3531-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.06 lbs

DESIGN	C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	AE	DRAWING NO.	REV. B
MFG. APPR.	AE	D3531	SHEET 4 OF 5
APPROVED	AE	TITLE	SCALE
DE APPR.	AE	BRACKET ASSEMBLY	NTS
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D3531-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

DESIGN	C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	J.C.		
CHECKED	J.C.	DRAWING NO.	REV. B
MFG. APPR.	J.C.	D3531	SHEET 5 OF 5
APPROVED	J.C.	TITLE	SCALE
DE APPR.	J.C.	BRACKET ASSEMBLY	NTS
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RELEASED
12/10/23 UP

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					